



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW895-3101-04-117-07

Job Sheet 199613



Part No: RBW895-3101-04-117-07

Job Qty: 4 pcs *9 conf*

Part Name: All Thread



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW895-3101-04-117 Rev 1 IPP Rev. A 19.08.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	4	10/14/19	10/14/19	0.00	1.00	Conventional Lathe - 1		<i>/</i>
		pcs					Conventional Lathe - 2		
110	QC 2	4	10/14/19	10/14/19	0.00	0.00	QC 2 - 1		<i>11/19/130</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S218573



Part: RBW895-3101-04-117-07

Job No: 199613

Serial No/Batch: S218573

Revision: 1

Inspector:

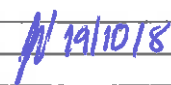
Exp Date:

Instructions:

Date: 08/28/19

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
115	Conventional Mill - 1 - B4B	4	10/14/19	0.00 0.40	Conventional Mill - 1 - B4B	
	pcs				Conventional Mill - 2 - B4B	
120	QC 2	4	10/14/19	0.00 0.00	QC 2 - 1	
	pcs				QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	4	10/14/19	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140	Packaging 3-1 - Stock - B4B	4 pcs	10/14/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	21
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	4 pcs	10/14/19	0.00 0.00	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 100 - (Manufacture as per dwg) 1-Machine as per DWG. DWG REV: <u>1</u> 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 115 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Deburr 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: <u>MLL</u>) 150 - (QC21- Final Inspection - Work Order Release) <u>135 SF & 136 QC5</u>					
Job BOM					
Part / Item Component Name		Quantity	Operation	Container	
90024A232 18-8 Stainless Steel Threaded Rod, M10 X 1.5 mm Thread Size, 500 mm Long <u>(19.685" long)</u>		.8400 (.21 ea)	100-Conventional Lathe - 1	<u>GA213</u> <u>S211719 S215734</u>	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	90024A232	1	0	0
Part Specifications				
Specifications could not be found.				

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DAS
03
9:00GAO 115
135RBW895-3101-04-117-1A~~117~~ ① each 3218979

98296A879

① each 3210614

DART AEROSPACE LTD		Work Order:	199613
Description: All Thread		Part Number:	RAW895-3101-04-117-07
Inspection Dwg: RAW895-3101-04-117		Rev: 1	Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by: <i>W</i>	Checked by: <i>W</i>	QC Inspector:
Date: <i>19/10/18</i>	Date: <i>19/10/18</i>	Date:

Engineering Approval: (If necessary)		Date:	
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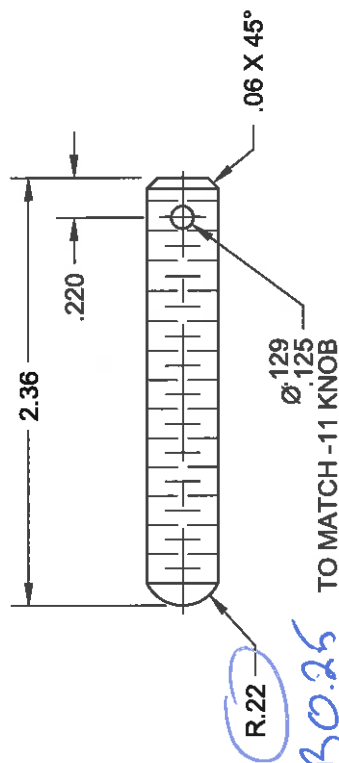
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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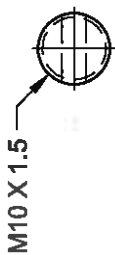
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-07 MOVED TO SEPARATE SHEET. CHD DIM WAS Ø.130 IS LIMITS Ø.125-.129.	2/14/14	DPD	GE

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199613 M

WORK ORDER NO. 199613 M3 190828



RC25 TO MATCH -11 KNOB
I > ACCEPTABLE
MkLa SPT 30/19



135 SF
136 acs

ALL THREAD
-07

 RED BARN MACHINE		RED BARN MACHINE	
TITLE		DATE	
M/R BLADE BLOCKING AND PROTECTOR TOOL		3-4-10	
DWG. NO.		SCALE	
RBW895-3101-04-117-07		1:1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		1. BREAK ALL SHARP EDGES	
TOLERANCES ON:		2. DIMENSIONAL LIMIT IS APPLY AFTER PLATING	
DECIMALS		0.015 ± .005 PR .015 R	
.xxx ± .01			
.xx ± .01			
.x ± .01			
FRACTIONS ± 1/32			
ANGLES ± 5°			
APPROVED		USED ON MODEL	
DRAWN BY:		AW1109, AW1119	
PERRITT			
TEST			
FINISH			
SPCC			
REV		SHEET	
1		6 of 9	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
		Skid-tube ☐		Quality ☐	
		Machining ☐			
		Large Fab ☐			
Date : _____	Sequence #: _____	QTY Affected : _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				